

Date: Wednesday, 14/01/2009 9:20:30 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARMREST KIT, LH
Job Number : 44750	
Estimate Number : 13564	
P.O. Number :	Part Number : D412761049
This Issue : 14/01/2009 S.O. No. :	Drawing Number : PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : 14/01/2009 Type : MACHINED PARTS	Drawing Revision : PRELIM
Previous Run : 41926	Material :
Written By :	Due Date : 19/01/2009
Checked & Approved By : <u>MF 09-01-13</u>	Qty: <input checked="" type="checkbox"/> Um: Each
Comment : Est Rev:A 08-09-10 new issue DD verified by:JLM Est Rev:B 09-01-13 rev.C as per dwg DD verified by:EC	



Additional Product

PRELIMINARY ISSUE

Job Number:



Donor B PCB Rev# 09-5029

Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



HJ for JLD 09/01/16



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-761-049 CHG001

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D3694041	MOUNTING PLATE
-----	----------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

MOUNTING PLATE

batch: B 44723

4.0	D3695041	Slider Assembly
-----	----------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Slider Assembly

batch: 44878

5.0	D3780041	Armrest Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Armrest Assembly

batch: 44534

1/2 shipped from Dart
 1/2 shipped from Aerolex
 waiting for cushion

W

Date: Wednesday, 14/01/2009 9:20:30 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARMREST KIT, LH

Job Number: 44750

Part Number: D412761049

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	AN36A	Bolt
-----	-------	------



Comment: Qty.: 11.0000 Each(s)/Unit Total : ~~22~~¹¹.0000 Each(s)

Bolt

batch: MW9752

Handwritten signature

7.0	AN626	Bolt
-----	-------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~2~~¹.0000 Each(s)

Bolt

batch: M/08110

Handwritten signature

8.0	AN3106	Castellated Nut
-----	--------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~2~~¹.0000 Each(s)

Castellated Nut

batch: 105279

Handwritten signature

9.0	AN960JD10	Washer
-----	-----------	--------



Comment: Qty.: 11.0000 Each(s)/Unit Total : ~~22~~¹¹.0000 Each(s)

Washer

batch: M109061

Handwritten signature

10.0	AN960JD616L	Washer
------	-------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~2~~¹.0000 Each(s)

Washer

batch: M109545

Handwritten signature

11.0	NAS1515H6L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~4~~².0000 Each(s)

WASHER

batch: M108818

Handwritten signature

12.0	MS24665285	Cotter Pins
------	------------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~2~~¹.0000 Each(s)

Cotter Pins

batch: 9003

Handwritten signature and date 9/1/2009

Date: Wednesday, 14/01/2009 9:20:30 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARMREST KIT, LH

Job Number: 44750

Part Number: D412761049

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS21071L3

ANCHOR NUT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

ANCHOR NUT

batch: 102587

1 2 20

14.0

MS21075L3

Nutplate



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nutplate

batch: M109371

20 9/01/20

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

ENGINEERING
APPROVAL

09.01.20

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-761-049

Location: _____

PPP Rev: _____

09/01/23 (x1)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/18

Job Completion



U 91.02.02

POSITIVE RECALL

EFFECTIVE 09.01.14 AUTH 1
RELEASED 09.02.17 DATE 09.02.17

Contract Review Form

Bill to:

Customer code: _____

O/E No: _____

Sales Rep: _____

NCR/RA No: _____

Customer P.O./Rev. No: _____

Ship to:

Requested Ship Date: _____

Customer Code: _____

Prepared by: _____

IRS/GST No: _____

Promise Date: _____

Receiver P.O No: _____

Billing Details:

Company Name: _____

Shipping Details:

Company Name: _____

Phone No/Email: _____

Phone No/Fax/Email: _____

Contact: _____

Comments/Status:

Freight _____ ☐ Prepaid ☐ Ppd & Chg

Waiting for \$ ☐

Acct No: _____ ☐ Collect

Waiting for Production ☐

Good to go ☐

Type of Service: _____

P/O Acknowledgement: _____

Qty	Part Number	Product Description	Batch	Discount	Price
1	D3696-041	Arm Assy	44542		
1	D3785-3	Bracket	44540		
3	AN96010L	Washer	101340		
3	MS21042L3	Nut	103816		
5	MS24693C223	Screw	108246		
3	MS24693C277	Screw	109297		
	6- D412 D3780-041				
		↳ D 412-761-049			
		↳ D 412-761-041			

Notes: _____

QUOTE/ORDER REVIEW	Order Proc	GM	DQA	Design Mgr	Prod Mgr
Inventoried Product					
Non-Inventoried Product/Custom Mfg./No charge					
Engineering Services					
OEM or Quotes/Orders over \$25,000 (US)					

Date: Friday, 09/01/2009 1:35:33 PM
User: Linda Lacelle

Dart Aerospace Ltd.

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : ARMREST ASSEMBLY

Job Number : 44534

Estimate Number : 13346

P.O. Number :

This Issue : 09/01/2009

S.O. No. :

Prsht Rev. : NC

First Issue : / /

Type : SMALL / MED FAB

Previous Run : 41919

Part Number : D3780041

Drawing Number : D3780 REVC PRELIM

Project Number : N/A

Drawing Revision : PRELIM

Material :

Due Date : 30/01/2009

Written By :

Checked & Approved By :

Comment :

Est Rev:A 08-05-26 new issue DD verified by:ec
Est Rev:B 08-07-22 revB as per dwg verified by:EC
Est Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Qty: Um:

Additional Product

Job Number:



PRELIMINARY ISSUE
Jard. 16
Per ECN#09-5028

Seq. #:

Machine Or Operation:

Description :

1.0

D3696041

Arm Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tube Assembly

batch:

Frans B44542 x1

2.0

D3781041

Cushion Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cushion Assembly

batch: 44535

3.0

D37853

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bracket

batch:

44540

4.0

AN96010L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch:

101340

5.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch:

M18816

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARMREST ASSEMBLY

Job Number: 44534

Part Number: D3780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS24693C273

Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total: 20.0000 Each(s)

Screw

batch:

M108246

SS 09/01/15

7.0

MS24693C277

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Screw

batch:

M109297

SS 09/01/15

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D3780

****torque screws as per dwg D3780****

to be assemble at Eagle

D3781-041
WILL BE SHIPPED
TO EAGLE BY
AEROTEX, 09.01.30

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL
09.01.30

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker as per dwg (see note 6) and Stock

Location:

9/1/30

SG

(1x)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

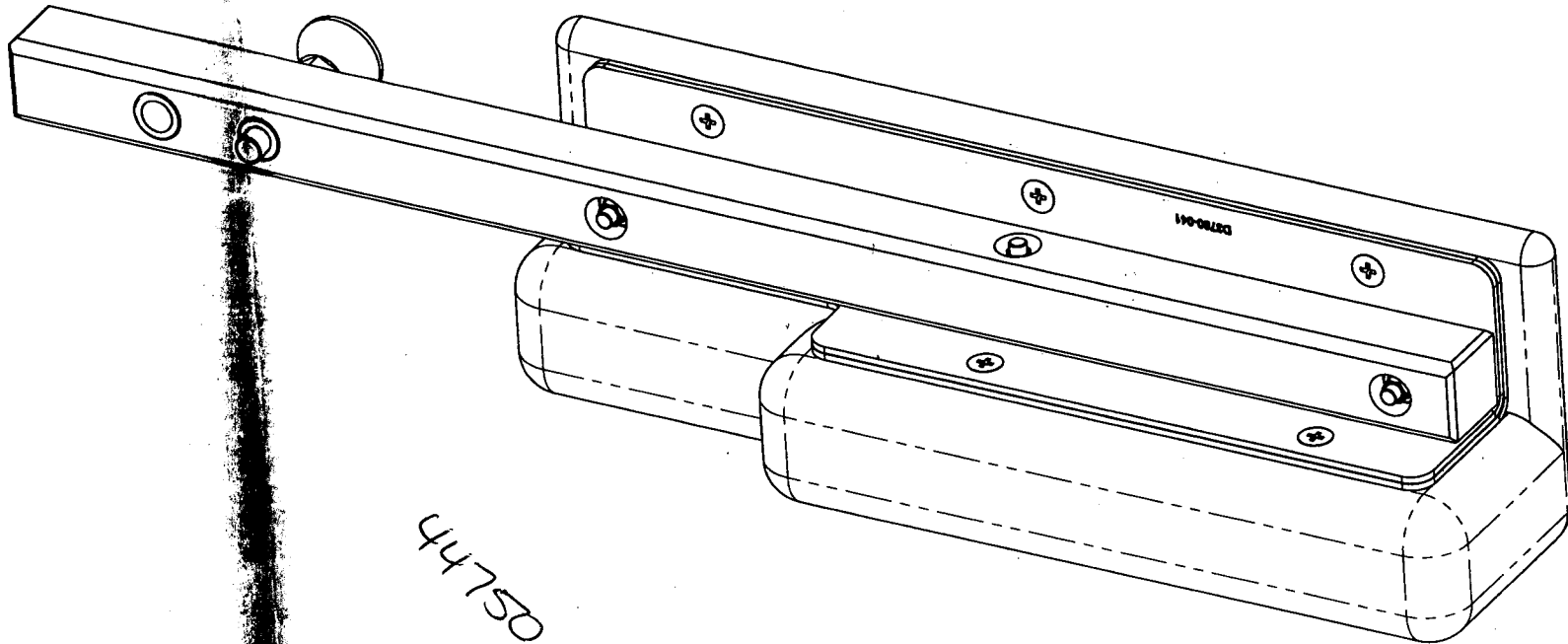


POSITIVE RECALL

EFFECTIVE 09.01.23 AUTH U

RELEASED DATE

D3780-041 ARMREST ASSEMBLY



44750

A

B

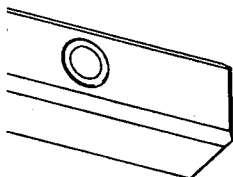
C

D

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041	ARM ASSEMBLY
4	1	D3781-041	CUSHION ASSEMBLY
5	1	D3785-3	BRACKET
7	3	AN960JD10L	WASHER
8	3	MS21042L3	NUT
9	5	MS24693-C273	SCREW
10	3	MS24693-C277	SCREW

C

QSLhh



PRELIMINARY ISSUE

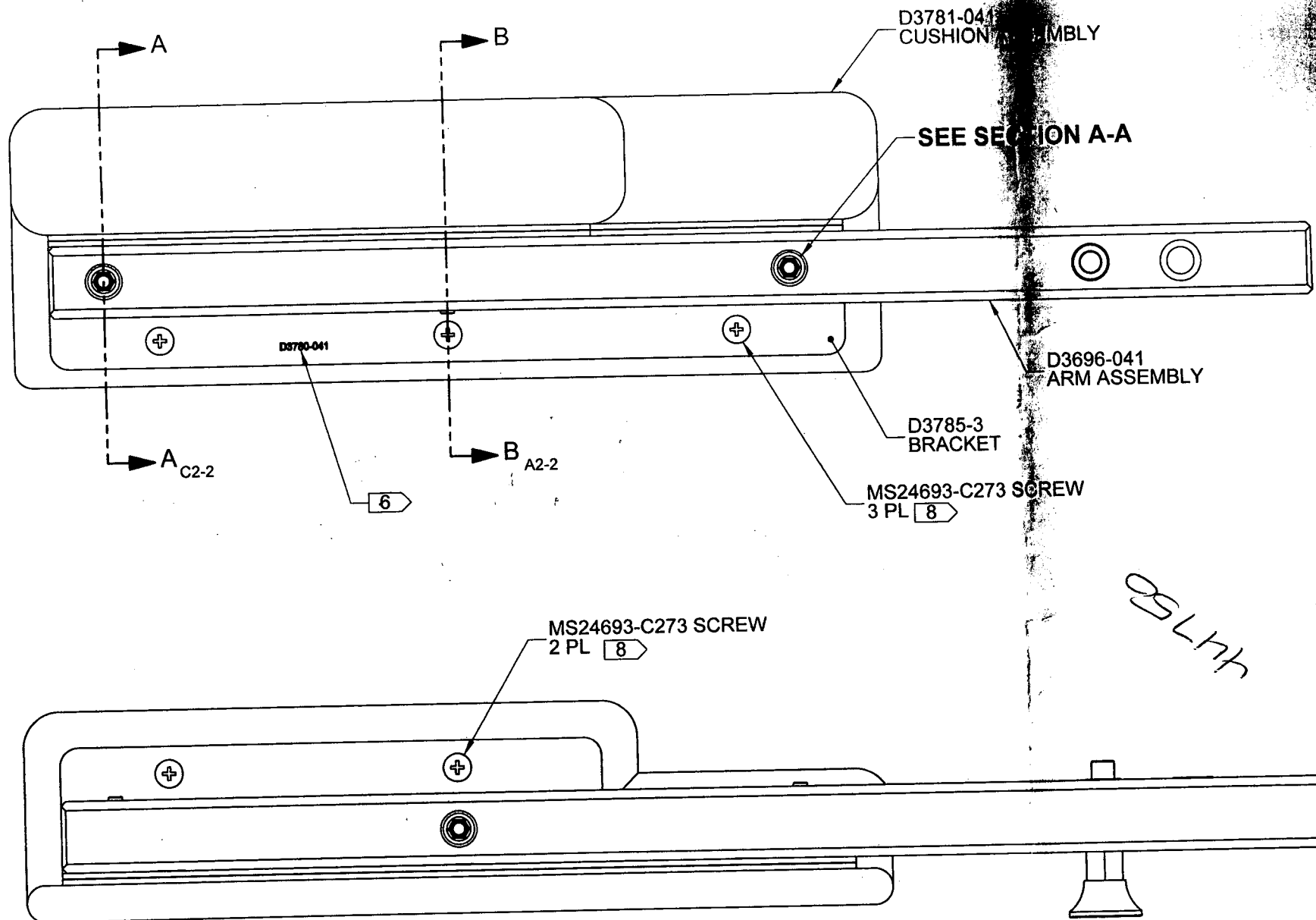
o.a. 16
PER ECN#09.502P

C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3780	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

D

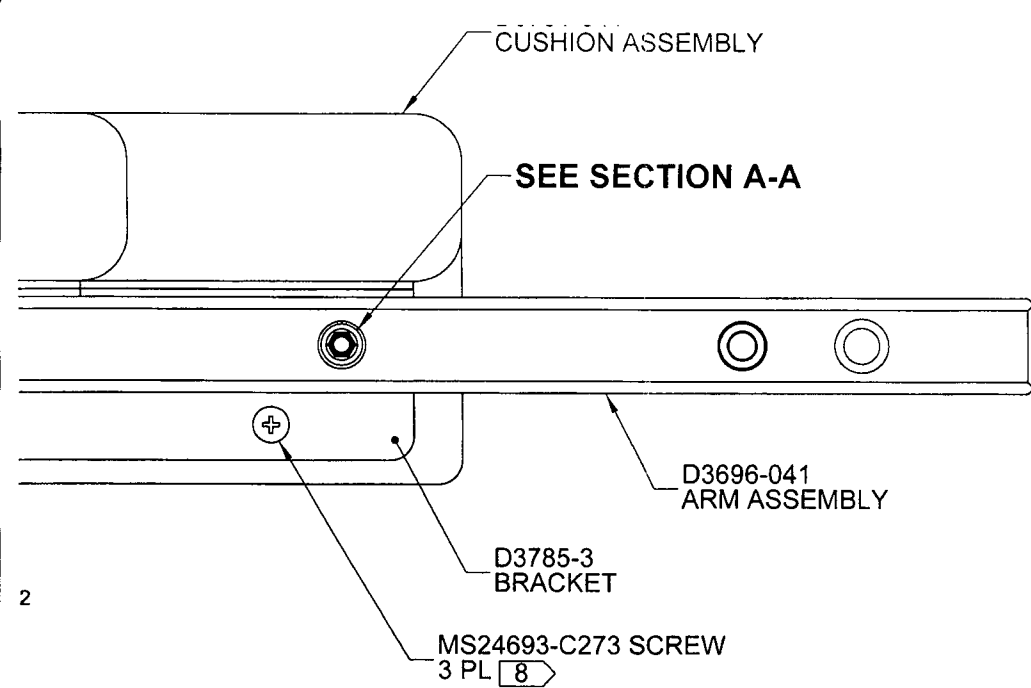
C

B

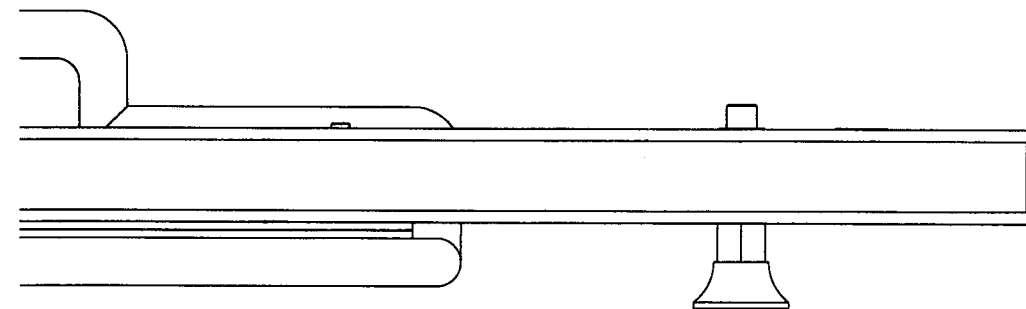


4475

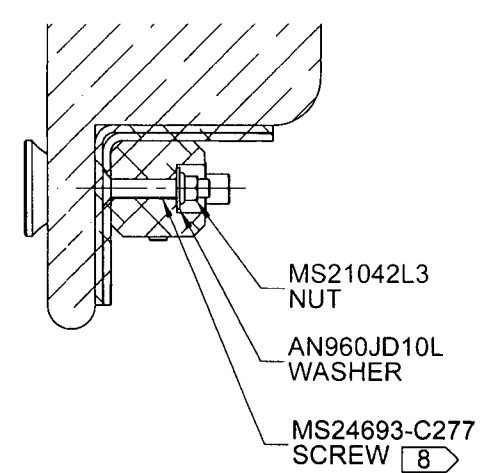
PRELIMINARY
L. C. O. R.
P. O. R.



MS24693-C273 SCREW
2 PL 8

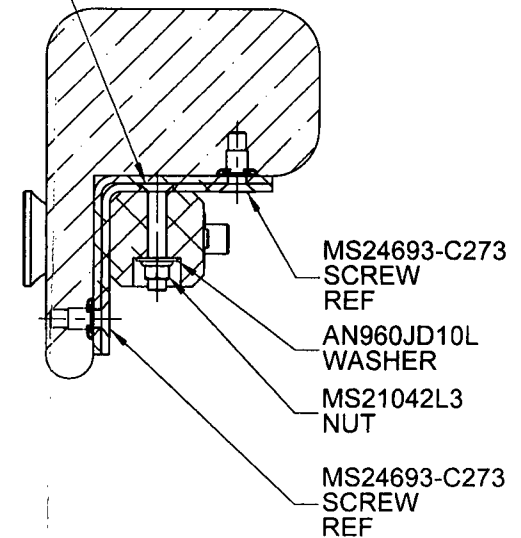


QSL 447



SECTION A-A
2 PL C7-2

MS24693-C277
8 SCREW

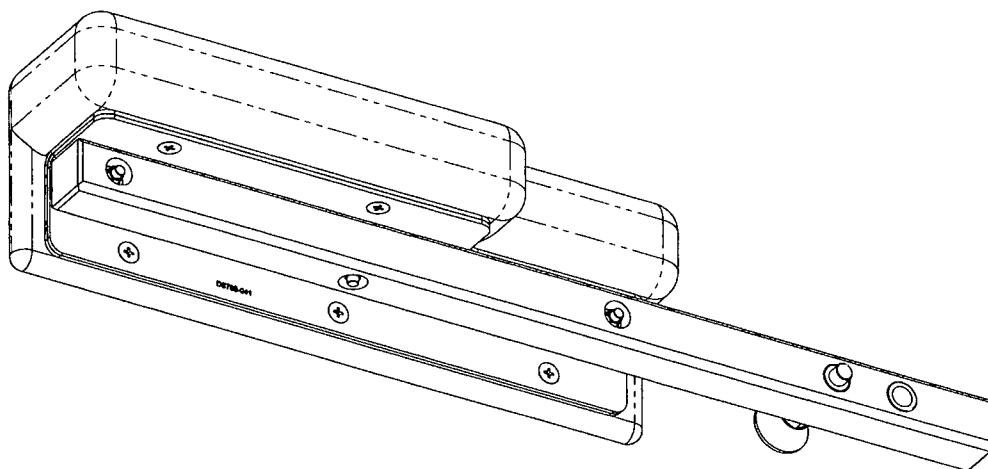


SECTION B-B
C6-2

PRELIMINARY ISSUE
14.09.16
Per Section 5028

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		
		DRAWING NO.

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041	ARM ASSEMBLY
4	1	D3781-041	CUSHION ASSEMBLY
5	1	D3785-3	BRACKET
7	3	AN960JD10L	WASHER
8	3	MS21042L3	NUT
9	5	MS24693-C273	SCREW
10	3	MS24693-C277	SCREW



D3780-041 ARMREST ASSEMBLY

44750

RELEASED
09/02/05

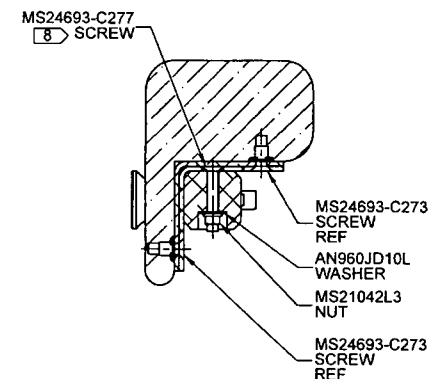
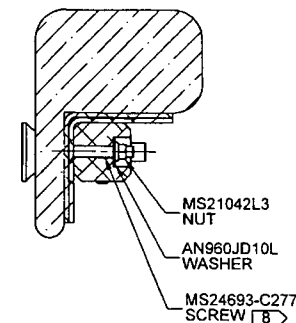
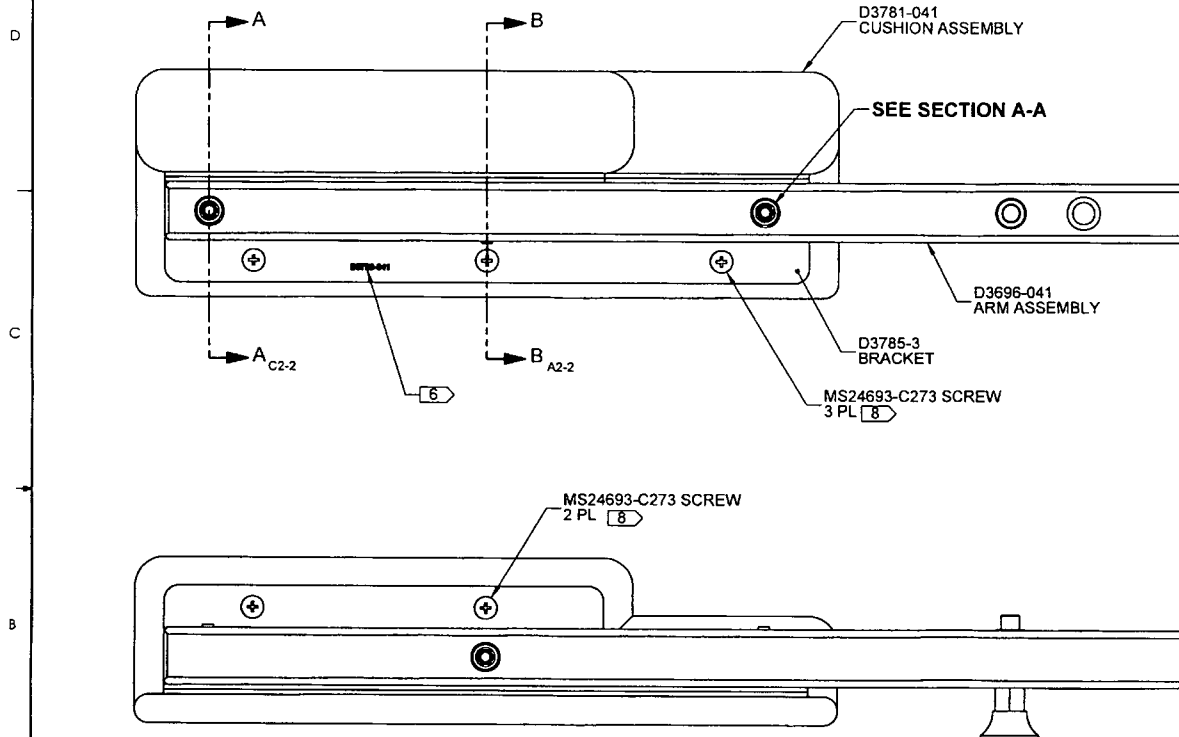
C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3780
REV. C
SHEET 1 OF 2
TITLE
ARMREST ASSEMBLY
SCALE
NTS

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8 7 6 5 4 3 2 1



44750

- D3780-041 NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: NONE
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3780-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
 - 7) WEIGHT: 2.61 lbs
 - 8) TORQUE SCREWS TO 20-25 in-lb.

DESIGN	1/8	DART AEROSPACE LTD	
DRAWN	1/8	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1/8	DRAWING NO. D3780	REV. C
MFG. APPR.	1/8		SHEET 2 OF 2
APPROVED	1/8	TITLE ARMREST ASSEMBLY	SCALE
DE APPR.	1/8		NTS
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RELEASED
8/6/05